



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4884-1
Job Sheet 187761



Part No: D4884-1

Job Qty: 10 pcs

Part Name: End Fitting, Eye



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/17/18

Job Tracking No:

Due Date: 1/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEET 1 IPP REV:A NEW ISSUE 14-01-13 JLM VERIFIED BY:DD IPP REV:B DOING PART IN HOUSE FROM NOW ON. RQ 16.11.02 VERIFIED BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
90	Start up Operation	10 Ea	1/4/19	1/4/19	0.00	0.00	Start Up Machining-3	
105	Doosan - 1	10 pcs	1/4/19	1/4/19	0.00	7.52	Doosan - 1	
106	Doosan - B4B	10 pcs	1/4/19	1/4/19	0.00	0.00	Doosan - 1 - B4B	
110	QC 2	10 pcs	1/4/19	1/4/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S144485



Part: D4884-1

Job No: 187761

Serial No/Batch: S144485

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/14/19

				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
115 HAAS 5 Axis - B4B	10 pcs	1/4/19	0.21 9.26	HAAS - 5 - B4B	19-02-11
117 QC 2	10 pcs	1/4/19	0.00 0.00	QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	19-02-11
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 38	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
120 QC 8	10 pcs	1/4/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	19-02-11
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
130 Outsource - 2 - NDT per QSI038	10 pcs	1/4/19		SKY002-VC	6 19-02-11
140 Packaging 2-1 - Receive - B4B	10 pcs	1/4/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Plex 1/14/19 9:00 AM Dart.Hadley.Shannon	

				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
150 QC 5	10 pcs	1/4/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				Packaging 3 - 1 - B4B	
160 Packaging 3-1 - Stock - B4B	10 pcs	1/4/19	0.00 0.00	Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	

FEB 14 2019

FEB 14 2019

DAS
68
9.89

				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	DAG 21 FEB 14 2019
				Packaging 3 - 32 - B4B	9-39
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
170 QC 21 - SA	10 pcs	1/4/19	0.00 0.00	QC 21 - SA - 21	DAG 21 FEB 14 2019
				QC 21 - SA - 70	9-39
Part Op 105 - (Doosan Lathe)-Machine blank as per Machinist's turning detail, folio+drawing D4884-1. Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 115 - (HAAS CNC vertical machine #5) Mill as per folio FB509. 117 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Outsource process - NDT per QSI038 4.1)ISSUE P/O 042571 140 - (Outsource process - NDT per QSI038 4.1) 150 - (QC5- Inspect part completeness to step on W/O) 160 - (Identify as per dwg & Stock Location:) IDENTIFY AS PER QSI 044 6.1 170 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M17-4-H900-R1.500	17-4 SS H900 Round Bar 1.500"	3.5000 ft (.35 ea)	90-Start up Operation	5129 892	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
90-Start up Operation	M17-4-H900-R1.500	4	70	0	
Part Specifications					
Specifications could not be found.					



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D4884-1
Job Sheet 187761



Part No: D4884-1

Job Qty: 10 ea

Part Name: End Fitting, Eye



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/17/18

Job Tracking No:

Due Date: 1/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEET 1 IPP REV:A NEW ISSUE 14-01-13 JLM VERIFIED BY:DD IPP REV:B DOING PART IN HOUSE FROM NOW ON. RQ 16.11.02 VERIFIED BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		1/4/19	0.00	0.00	Start Up Machining-3		
105	Doosan	10 pcs		1/4/19	0.00	7.52	Doosan		
110	QC	10 pcs		1/4/19	0.00	0.00	QC2 Machining-3		
115	CNC Vertical Machining	10 pcs		1/4/19	0.21	9.26	HAAS 5 Axis		
117	QC	10 pcs		1/4/19	0.00	0.00	QC2 Machining-3		
120	QC	10 pcs		1/4/19	0.00	0.00	QC8 Machining-3		
130	Outsource	10 pcs		1/4/19			SKY002-VC	6	
140	Packaging	10 pcs		1/4/19	0.00	0.00	Packaging2		
150	QC	10 pcs		1/4/19	0.00	0.00	QC5		
160	Packaging	10 pcs		1/4/19	0.00	0.00	Packaging3-2		
170	QC21-SA	10 Ea		1/4/19	0.00	0.00	QC21		

Part Op 105 - Machine blank as per Machinist's turning detail, folio+drawing D4884-1.
Descriptions: 115 - Mill as per folio FB509.

130 - ISSUE P/O :

160 - IDENTIFY AS PER QSI 044 6.1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R1.500	17-4 SS H900 Round Bar 1.500"	3.5000 ft (.35 ea)	90-Start up Operation	5129 892

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-R1.500	4	76	0



Container No: S144485



Part: D4884-1

Job No: 187761

Serial No/Batch: S144485

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/14/19

IS

e found.

Plex 12/17/18 7:44 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY Other/Details:			

DART AEROSPACE LTD		Work Order:	187761
Description: End Fitting, Eye		Part Number:	D4884-1
Inspection Dwg: D4884 Rev: A		Page 1 of 1	

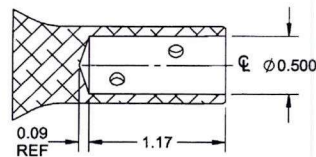
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500	+0.006/-0.001	.500	✓		Vern LPO9	
1.17	+/-0.030	1.150			↓	
R0.63	+/-0.030	0.625			Rad gage	
0.500	+/-0.005	.500			Vern LPO9	
0.030	+/-0.010	.020			↓	
0.017	+/-0.010	.017			↓	
Ø0.670	+0.000/-0.001	.6695			Mic LPO9	
30°	+/-0.5°	30°			Protractor	
Ø0.125	+0.004/-0.001	.125			gage pin	
30°	+/-0.5°	30°			Protractor	
Ø0.125	+0.004/-0.001	.125			gage pin	
Ø1.14	+/-0.030	1.140			Vern LPO9	
1.132	+/-0.010	1.133	✓		SL10	Vern
Ø0.750	+0.000/-0.001	.7493	✓		SL02	Mic
0.66	+/-0.030	.6576	✓		SL10	Vern
2.060	+/-0.005	2.062	✓		1	
R0.25	+/-0.030	.250	✓		Rad gage	
1.81	+/-0.030	1.810	✓			
3.65	+/-0.030	3.650	✓			
0.06 x 45°	+/-0.030 x +/-0.5°	.056 x 45°	✓			
0.947	+/-0.010	.948	✓			
0.059	+/-0.010	.058	✓			
0.063	+/-0.010	.0625	✓		Rad gage	
R0.06	+/-0.030	.062	✓			
0.200	+/-0.010	.200	✓		1	
R0.25	+/-0.030	.250	✓		Rad gage	
1.39	+/-0.030	1.390	✓		↓	

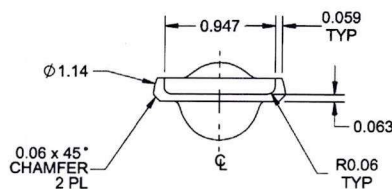
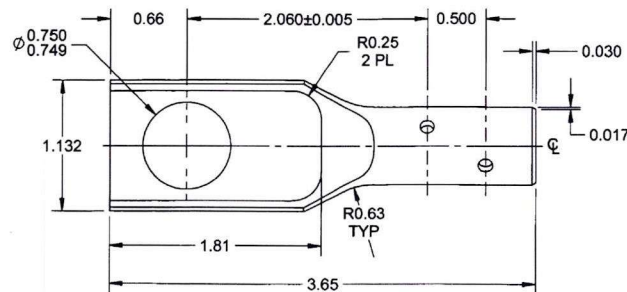
Measured by: <i>PJ</i>	Checked by: <i>amyl</i>	QC Inspector:
Date: 19-01-13	Date: 14/02/11	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

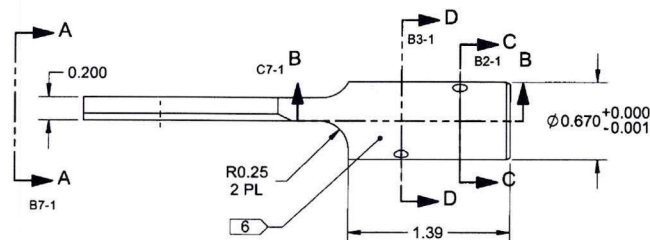
Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	<i>[Signature]</i>



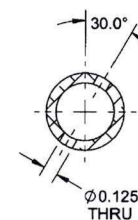
SECTION B-B C5-1



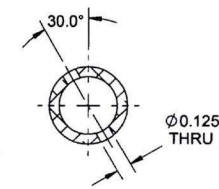
VIEW A-A B6-1



D4884-1 END FITTING, EYE



SECTION C-C C4-1



SECTION D-D C5-1

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.13 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	DC		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS		
DATE	13.12.01		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4884 REV. A SHEET 1 OF 2 TITLE END FITTING SCALE NTS COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042571



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO042571
PO Date: 2/11/19
Due Date: 2/15/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	187761	D4884-1	End Fitting, Eye : Various STC's (Outsource process - NDT per QSI038 4.1)ISSUE P/O	Firmed	-	2/15/19	6 pcs	0 pcs	6 pcs	\$50.857142/pcs	\$305.14
Line Item Note ** need asap **											
2	OH189825	C10-OH	C-Series Remote Hook 10,000 lbs Lift Capacity	Firmed	-	2/15/19	1 pcs	0 pcs	1 pcs	\$50.857142/pcs	\$50.86
Line Item Note Includes: C10-12 - selenoid C10-23 - Keeper Weldment											
Grand Total:										\$356.00	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO39292	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO042571
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON :

6 END FITTINGS . P/N# D4884-1, J/S# 187761

1 C-SERIES REMOTE HOOK ASSY(14 PCS) , P/N# C10-OH , J/S# OH189825 = 14 PCS.

Action Taken:						Date:	Initial/Stamp:
LPI & MPI C/O IAW ASTM E-1417M-16 AND ASTM E-1444M-16 ***NO CRACK FOUND*** PEN , ZL-37 MPO#: 23206 CLEANER SKC-S MPO15030, EMU.(ZR-10B, MPO23451), DEV. MPO15030, UV LIGHT M-20142 MAGBENCH S/N 208123 CAL DUE: 05-APR-2019 POWDER 14A BATCH# MPO13600 CARRIER II BATCH# MPO13923 BLACK LIGHT-M20186						12 FEB 2019	
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:		ACA/SCA Stamp	Date:
Name:	Arronino Manicheth		12 FEB 2019.

DATE: 2019/02/01

N.D.T

MODEL: C10

S/N : M883-01

Job : OH189825 RA.# 562

P/N	DESCRIPTION	QUANTITY
C10-1	SIDE PLATE (SELENOID)	1
C10-2	" " MRK	1
C10-5A	LOAD BEAM	1
C10-6	TRUCTION	1
C10-10-1	ACTUATOR SHAFT	1
C10-9-1	LATCH	1
C10-9-5	LATCH SHAFT	1
C10-4	LOCK	1
C10-4-4	UPPER LOCK LOWER SHAFT	1
C10-4-5	lower lock "	1
C10-4-3	UPPER LOCK ROLLER	1
C10-4-2	LOWER LOCK ROLLER	1
C10-4-11	LOCK SHAFT	1
C10-23-1	KEEPER SPACER	1

ALAN PATRY


 JOTAP
 61
 12 FEB 19

ANTONINO Marchetti
 12 FEB 19 MW0 39252